

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023872**Date Inspected:** 20-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for random observations relative to the work being performed.

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On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

**Trial Assembly**

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

ZPMC QC is identified as Xie Ming Feng and ABF QA Sha Zhi.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components; OBG 13BE

PCMK: OBE 13B

Weld No: 002

Welder: 044772

Weld Repair No. B-WR21047

WPS-345-SMAW-4G(4F)-ESAB-Repair-1

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Components; OBG 13CE  
PCMK: SEG3011M  
Weld No: 122  
Welder: 058102  
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 13CE  
PCMK: SEG3011N  
Weld No: 286  
Welder: 058102  
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 14 E  
PCMK: SEG3019X  
Weld No: 098  
Welder: 058102  
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 13CE  
PCMK: SEG3019Z  
Weld No: 015  
Welder: 058102  
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 13AW  
PCMK: 13BW  
Weld No: 122  
Welder: 068720  
WPS-B-P-2212-TC-U4b-FCM-1

Components; OBG 13AW  
PCMK: DP4234-001  
Weld No: 018  
Welder: 068720  
WPS-B-P-2212-TC-U4b-FCM-1

This QA Inspector observed the following work in progress for Trial Assembly.  
ZPMC was using the Flux Core Arc Welding (FCAW) process.  
ZPMC QC is identified as Xie Ming Feng and ABF QA Sha Zhi.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

Components; OBG 13CW  
PCMK: CA3016A

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Weld No: 102  
Welder: 070101  
WPS-B-T-2231-ESAB

This QA Inspector observed the following work in progress for Trial Assembly.  
ZPMC was using the Shielded Metal Arc Welding (SMAW) process.  
ZPMC QC is identified as Zhan Hal Fang and An Qing Ziang.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

Components; OBG 14E PP123  
PCMK: DP3160-001  
Weld No: 381  
Welder: 052696  
Weld Repair No. B-WR21038  
WPS-345-SMAW-1G(1F)-FCM-Repair-1

This QA Inspector observed the following work in progress for Trial Assembly.  
ZPMC was using the Flux Core Arc Welding (FCAW) process.  
ZPMC QC is identified as Zhan Hal Fang and An Qing Ziang.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector.

Components; OBG 13AE  
PCMK: SEG3007AY  
Weld No: 028,021,019  
Welder: 050242  
WPS-B-T-2232-ESAB

Components; OBG 14W  
PCMK: SP3142-001  
Weld No: 021~030  
Welder: 037705  
WPS-B-T-2233-ESAB

Components; OBG 14W  
PCMK: BP3093-001  
Weld No: 001~012  
Welder: 067275  
WPS-B-T-2232-ESAB

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG Deck Plates. The weld designations reviewed are as follows:

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## WELDING INSPECTION REPORT

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DP3073-001-059~063,155,085~089,161

DP3075-001-091~095,251,131~135,261

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member was identified as OBG Longitudinal Diaphragm to Floor Plate. The weld designations reviewed are as follows:

SEG3011K-118

SEG3009L-257

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

“No relevant conversations.”

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Leavitt,Kelly
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley,Ken
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QA Reviewer
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